

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000765**Date Inspected:** 29-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Jian Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG second weld trial**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication of the 10 meters U-ribs Weld Trial scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector performed bevel angle verifications on the u-ribs U-73, U-01, U-75,U-02 and U-05 for the second OBG weld trial. The QA inspector took 10 measurements for every U-rib (50 total) approximately equidistant apart and approximately at the same location where ZPMC QC personnel measured the bevel angles. The QA inspector obtained bevel angles from 25 degrees and 45 minutes to a maximum of 28 degrees and 15 minutes and an average bevel angle of approximately 27 degrees. Also, the QA inspector performed dimensional inspection to the u-rib U-05 at the inspection platform (multiples platforms). The QA inspector verified with the assistance of the QA inspector Larry Viars the U-rib U-05 straightness, gaps, warpings, high and template check (b). The QA inspector found that the dimensions appeared to be in general compliance with ZPMC fabrication procedure and the contract documents.

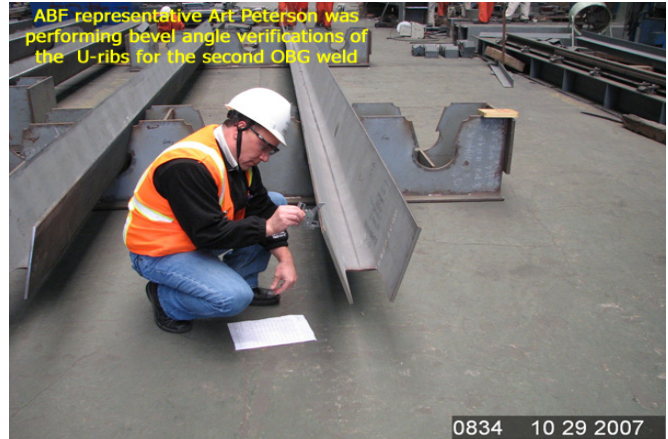
The photographs below show ABF representative Mr. Art Peterson performing dimensional verifications to the U-ribs for the second weld trial, Caltrans QA inspector Mr. Larry Viars and ZPMC representative Mr. Fu Yu Hong setting up before the straightness verifications of the U-rib U-05 and the Uribs U-73, U-01, U-75,U-02 and U-05 positioned over the deck panel after Caltrans QAs completed the dimensional verifications.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As noted above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Acuna,Alfredo	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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